

Work Order ID 59955

Monday, June 21, 2010 7:53:08 AM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 6/21/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 10-6-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	A								
100	Weld per dwg A/R S.S. rod Batch: <i>M113328</i>	0.00							
	Large Fab								
Large Fab	Memo	0.00							
	1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket***								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

MS 10/07/07 (1x)

CP 10.07.07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8 10 6 2 1 0 7

10

10 7-7.

10 7-7.

10 7-7.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-7-77	10/10	Perm. Change ADD THAT PROCEDURE TO WORK ORDER. Pressure wash.	BR M	10-7-77 10.07.13			S 6/07/08	

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

E80/07/08 @

150



HandFinish

Hand Finishing

Assemble as per dwg

0.00

Memo

Pick Kit

0.00

E80/07/08 @

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S120708

④

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



Packaging

Identify as per dwg & Stock Location: G-A

0.00

Memo

0.00

Packaging

Handwritten: 6/10 59954
6/20/07/08 @

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Handwritten: 10-7-8
ME 10-7-8

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Picklist Print

Monday, June 21, 2010 7:53:08 AM

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Work Order ID: 59955



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/21/2010

Required Date: 6/28/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC
IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	41.0000	2	2		10/07/05	

Location	Loc Qty	Loc Code
ST	15	
59121	15	
WA	26	
46086	2	
51745	2	
57185	1	
59265	21	

D3913-1 Rib		Manufactured	No			100	Each	3.0000	1	1		10/07/05	
--------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA	3	
59337	3	

D3913-15 Wide Handle Plate		Manufactured	No			100	Each	5.0000	1	1		10/07/05	
-----------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA	5	
58125	2	
58586	3	

W/O:		WORK ORDER CHANGES						
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Work Order ID: 59955

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/21/2010

Required Date: 6/28/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-3

 Rib

Manufactured No

100

Each

3.0000

1

1



SY 10/07/05

Location

Loc Qty

Loc Code

WA

3

59338

3

①

✓ D3913-7

 Rib

Manufactured No

100

Each

7.0000

2

2



B58690 ① SY 10/07/05

Location

Loc Qty

Loc Code

WA

7

59339

4

59743

3

② ②

✓ D3913-9

 Hinge Rib

Manufactured No

100

Each

3.0000

1

1



SY 10/07/05

Location

Loc Qty

Loc Code

WA

3

59731

3

①

✓ D3916-041

 Rib Assembly

Manufactured No

100

Each

2.0000

2

2



B59732 ② SY 10/07/05

Location

Loc Qty

Loc Code

WA

2

59340

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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[illegible]

.....

Required Date: 6/28/2010

Required Qty: 1.00

3

3
BS9935 (2) 10/07/05

Loc Code

4

2

2

9.0000

①
3
10/07/05

Loc Code

WA

9

59536

9

4 0000

③
1
LM 10/07/05

Loc Code

WA

4

58929

2

59537

2

8.0000

①
2
SY 10/07/05

Loc Code

WA

8

59335

2

59538

6

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Work Order ID: 59955



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/21/2010

Required Date: 6/28/2010

Start Qty: 1.00

Required Qty: 1.00

D4020-1 Manufactured No

100

Each

2.0000

1

1



Mesh (350 Basket Long, Base)



10/07/05

Location

Loc Qty

Loc Code

WA

2

59555

2

D4020-11 Manufactured No

100

Each

8.0000

2



End Mesh, Basket



858931 ① 10/07/05
1359942 ②

Location

Loc Qty

Loc Code

WA

8

56990

1

58136

1

59413

6

D4021-1 Manufactured No

100

Each

19.0000

3

3



Handle Plate



10/07/05

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA

14

59336

5

59746

9

D4034-041 Manufactured No

100

Each

5.0000

1



Aft Upper Rib Assembly



10/07/05

Location

Loc Qty

Loc Code

WA

5

58729

2

59747

3

①

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Shop Packet Print

Page 4

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Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/21/2010

Required Date: 6/28/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D4034-043 Manufactured No 100 Each 2.0000 1 1
Fwd Upper Rib Assembly



~~B58694~~ ① 10/07/05
B58730

Location Loc Qty Loc Code

WA 2
58730 2

AN3-10A Purchased No 150 Each 6.0000 6 6
Bolt



SB 10/07/12

Location Loc Qty Loc Code

ST351 6
114330 6

* AN960JD8 NAS1149DN832J Purchased No 150 Each 0.0000 2 2
Washer



④ M114740 ②

M115016 ⑥
E 5/0/07/08

D2931 Manufactured No 150 Each 830.0000 2 2
Bumper



E 5/0/07/08

Location Loc Qty Loc Code

ST504 830
46064 830

D4021-5 Manufactured No 150 Each 7.0000 2 2
Blanking Plate



2
E 5/0/07/08

Location Loc Qty Loc Code

ST111 7
59096 7

2

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Shop Packet Print

Page 5

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Work Order ID: 59955

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/21/2010

Required Date: 6/28/2010

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

1,645.000

2

2



Cherry Rivets



Ep 10/07/08

Location

Loc Qty

Loc Code

ST321

1645

106375

3

107939

822

111636

820

MS21042L3

Purchased

No

150

Each

3,105.000

6

6



Nut



Ep 10/07/08

Location

Loc Qty

Loc Code

ST300

3105

114523

605

114718

500

114784

2000

NAS1149F0332P

Purchased

No

150

Each

731.0000

12

12



WASHER



Ep 10/07/08

Location

Loc Qty

Loc Code

ST275

731

18057

731

22

Monday, June 21, 2010 7:53:08 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

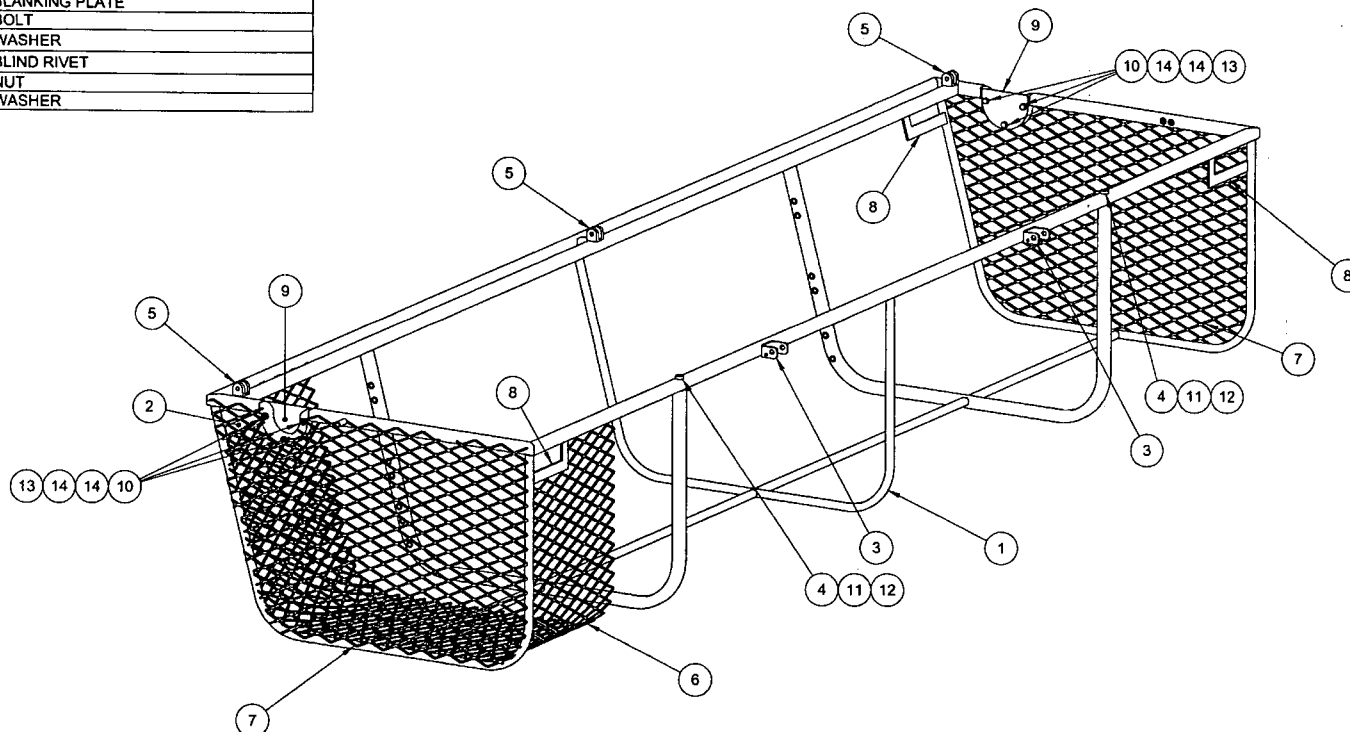
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
WNT

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE		10.03.16	
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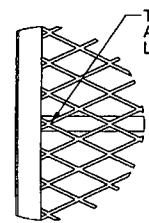
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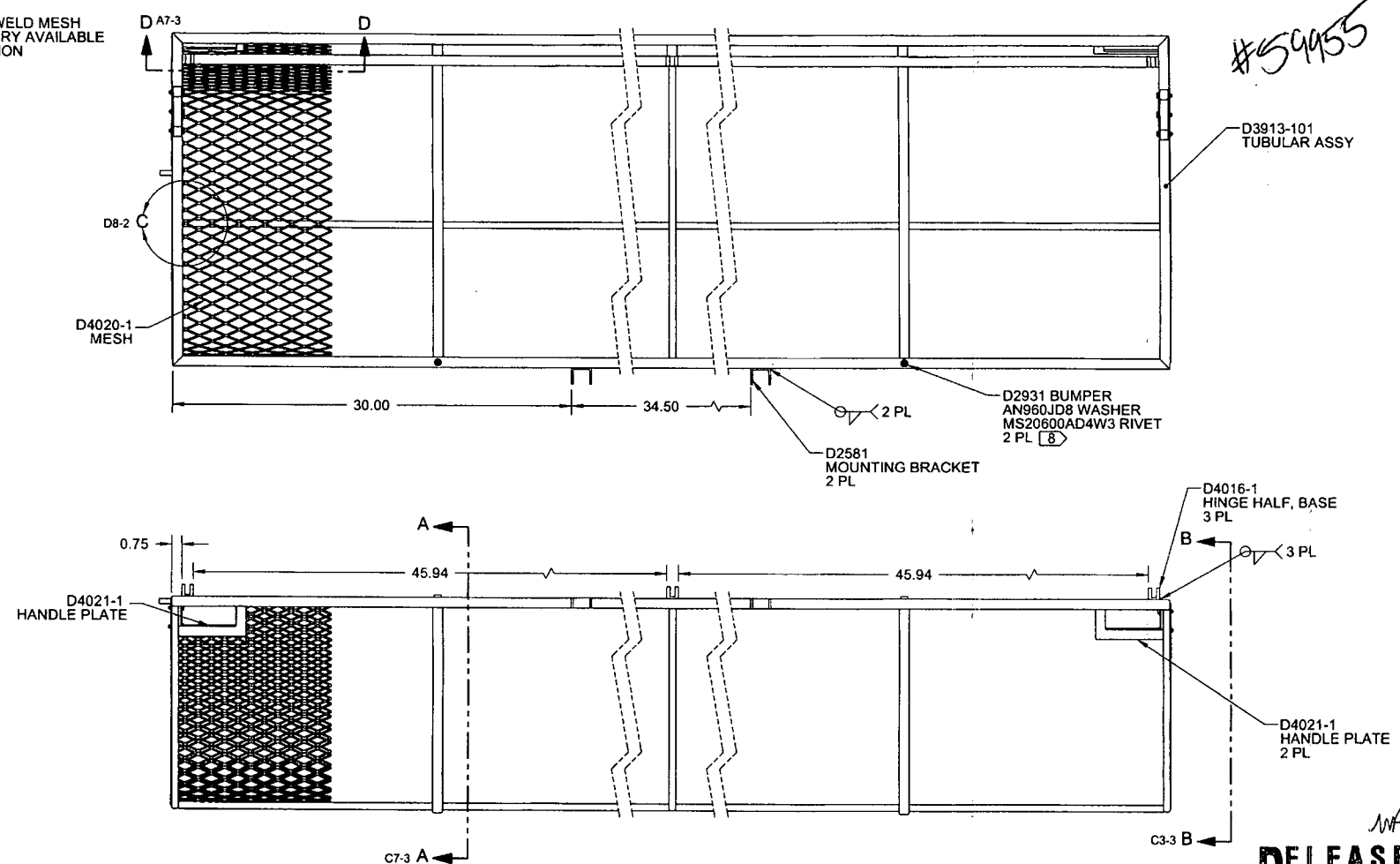
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NOTE: Date & initial all entries



DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

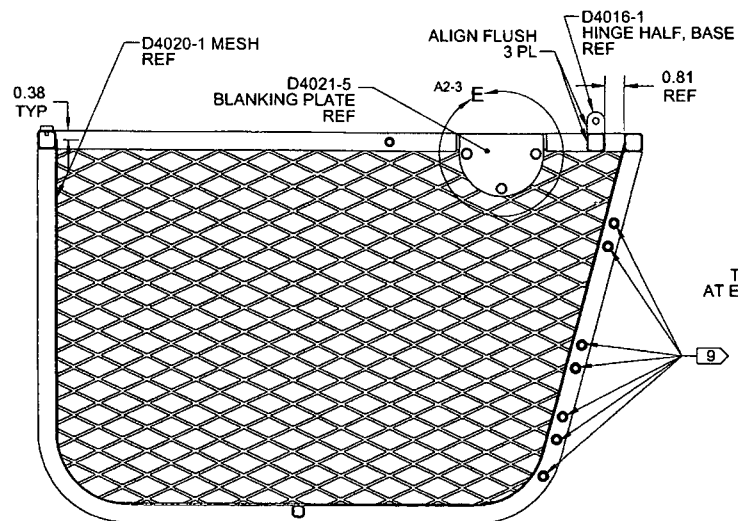
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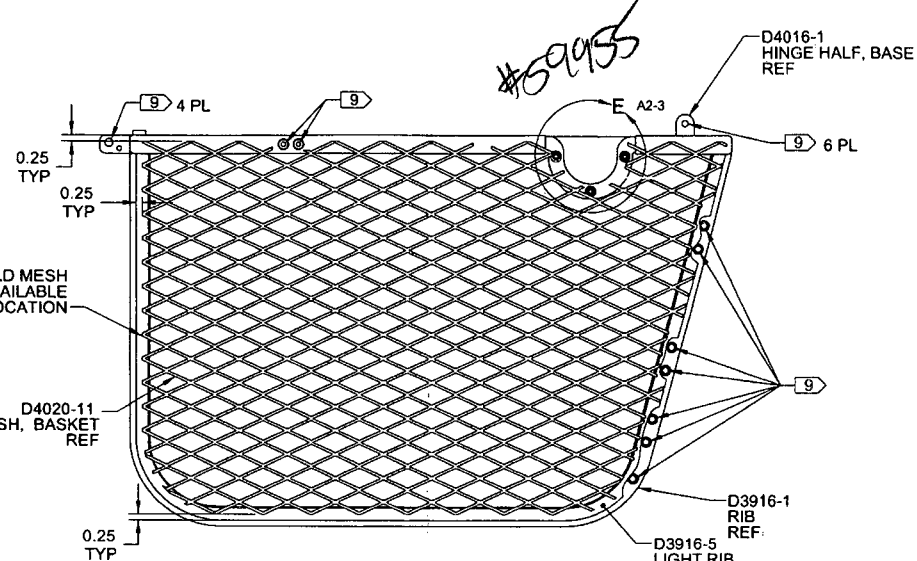
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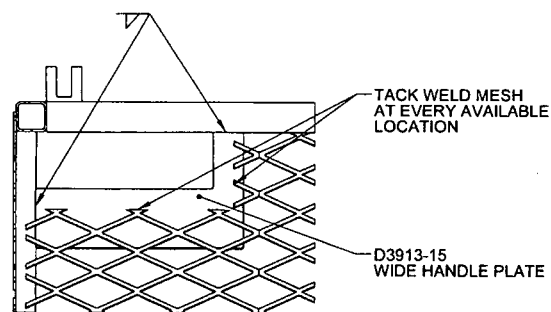
NOTE: Date & initial all entries



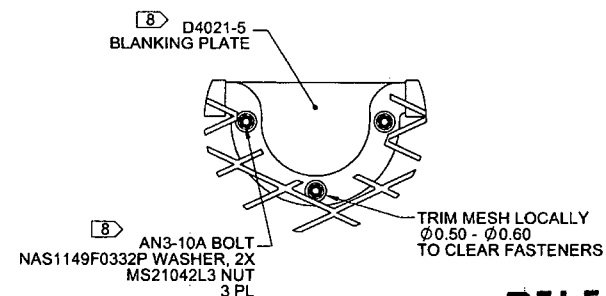
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	R	DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	<small> COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD </small>	

RELEASED
2010-03-22

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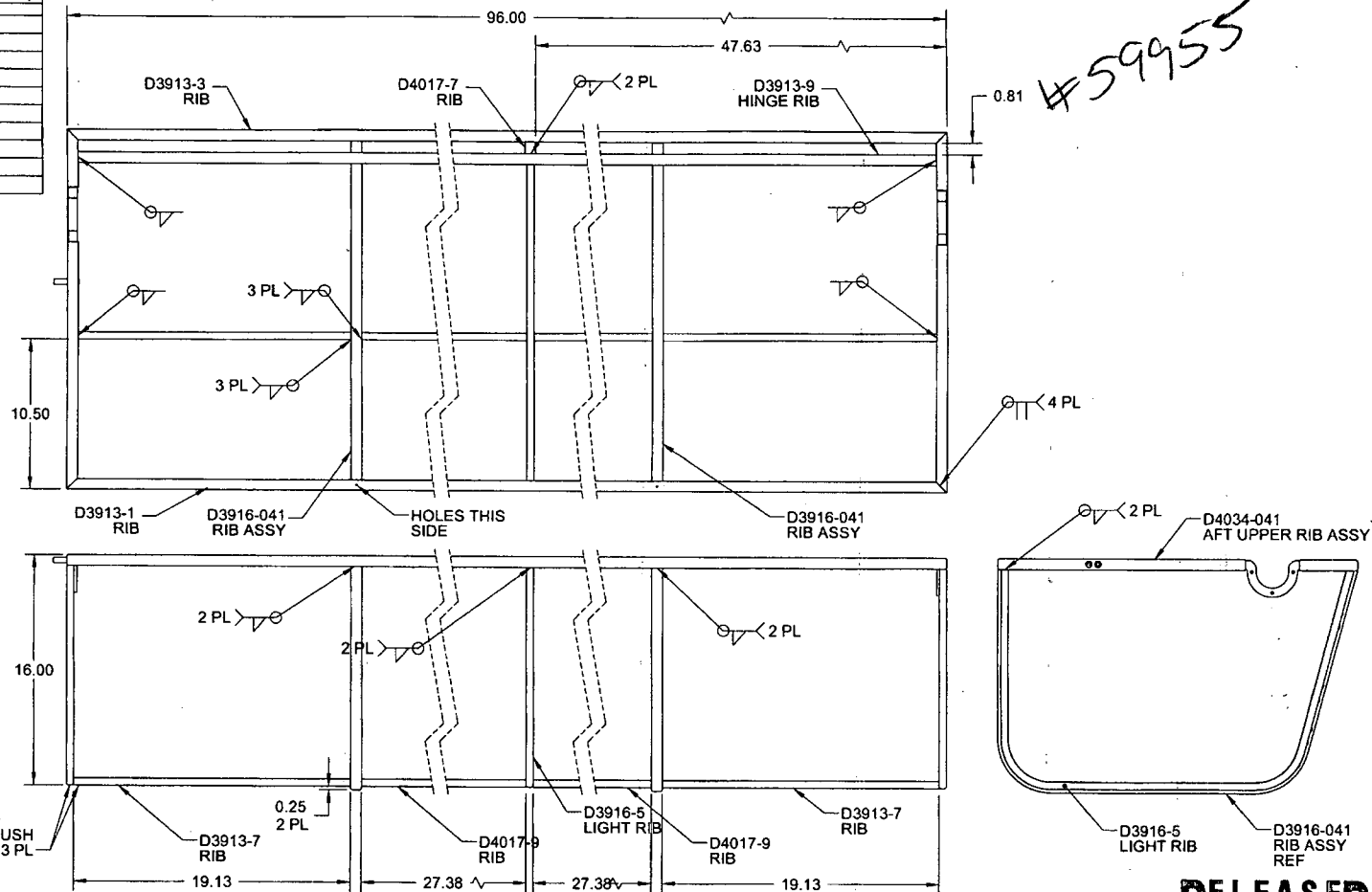
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	A	DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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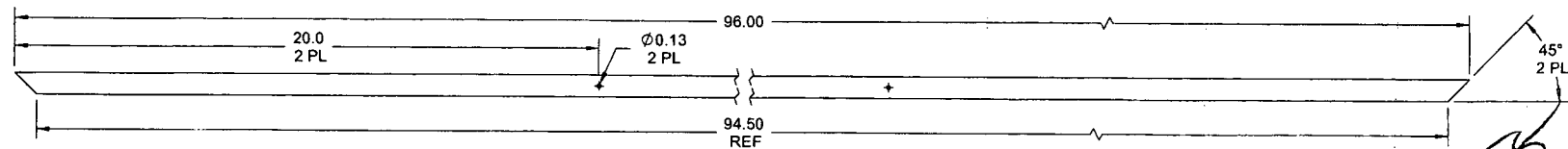
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

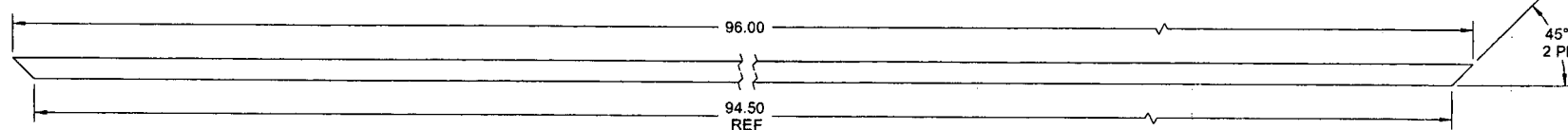
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

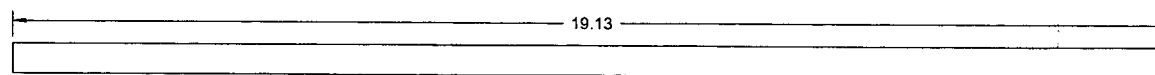
NOTE: Date & initial all entries



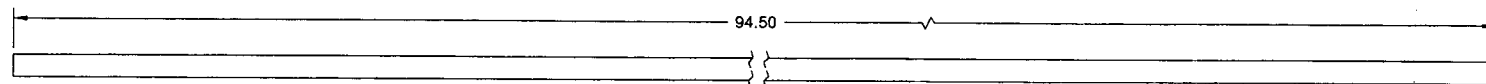
D3913-1 RIB



D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB

NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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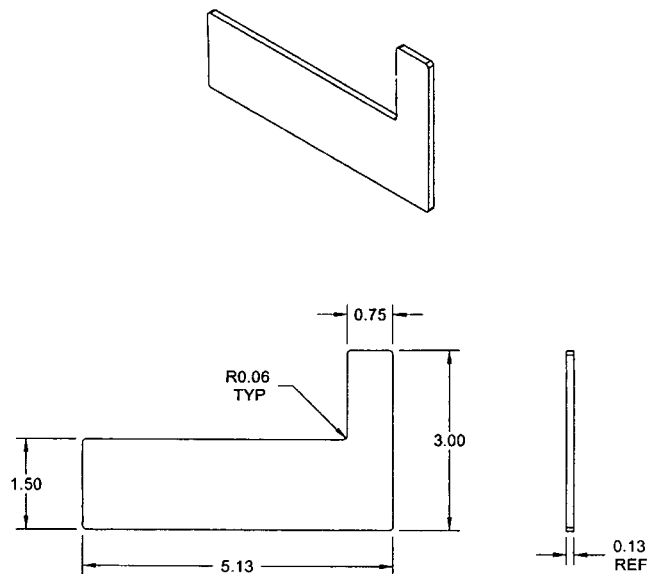
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries